

Work Order ID 60059

June 24, 2010 8:18:40 AM



Page 1

Item ID: D2037-101

Accept



Setup Start



Revision ID:

Item Name: Arm

Stop



Start Date: 6/24/10

Start Qty: 10.00



Cust Item ID:

Required Date: 6/25/10

Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Punch as per Dwg D2037. Keep hole distance 45.50" using Jig D2037-101T1

SB 10/06/24

10

P10

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Drill Ø0.323" holes in D2037-101 tube as per Dwg D2037
ends of D2037-101 tube as required using DT8545
3-Deburr as required

2-Flatten

=> m-p

10/07/06

10X

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 10/07/06

10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10.07.06	W/O chg header	Add chg info into Box Perm change	<i>[Signature]</i>	10.07.07		<i>[Signature]</i> 10.07.06	<i>[Signature]</i> 10.07.06

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60059

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Page 2

Item ID: D2037-101

Accept

Revision ID:

Item Name: Arm

Start Date: 6/24/10 Start Qty: 10.00

Required Date: 6/25/10 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

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Tooling:

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QC:

Date:

SPC (Y/N):

Date:

Setup

Start

Stop

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location: *W/A*

Memo

0.00

0.00

BZ

10-7-8

(X10)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

100A-08

MF

10-7-8

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Picklist Print

June 24, 2010 8:18:39 AM

Page 1

Work Order ID: 60059

Parent Item: D2037-101

Parent Item Name: Arm



Start Date: 6/24/10

Start Qty: 10.00

Required Date: 6/25/10

Required Qty: 10.00

Comments: IPP Rev:A New Issue 05-11-01 JLM
IPP Rev:B 08-07-29 revD as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			110	f	471.7568	3.916	41.22105			

304 RD Tube .750 x .049W

Location	Loc Qty	Loc Code
MAT	443.89334	
108498	0	
110113	0	
114482	6.6065	
114852	137.28684	
115010	300	
MAT017	27.8635	
109314	9.33	
110113	5.29	
112800	13.2435	

43

8/10/06/24

10

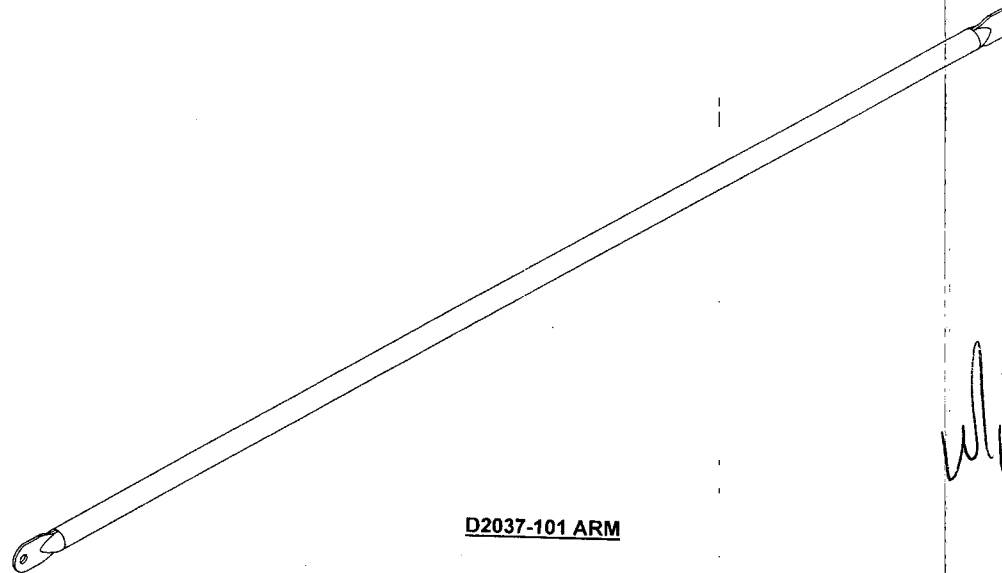
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D2037-101 ARM

Wb 60059

RELEASED
08.07.07

NOTES:

- 1) MATERIAL: AISI 304/316, STAINLESS STEEL ROUND TUBE, $\phi 0.750 \times 0.049$ WALL
REF. DART SPEC M304TR0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.50 lbs
- 8) FOR FURTHER INFO SEE DRAWING D2638.

REV.	DESCRIPTION	BY	DATE
D	INCORPORATED C1, C2 & C3. REDRAWN TO SOLIDWORKS FORMAT WITH CURRENT STANDARDS. ORIGINAL "SQUARE END" CONFIGURATION DELETED (SEE REV. C FOR FURTHER DETAILS). SHEET 2 DETAIL A NOW INDICATED AS 2 PL. REASON FOR CHANGE: QC/PRODUCTION REQUEST.	AJS	08.05.08
C	REDRAWN, 0.386 WAS 0.375.	RF	99.06.07
B	-103 DELETED	JB	93.04.20
A	NEW ISSUE	JB	91.10.22
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D2037	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ARM	NTS
DATE	08.05.08	<small>COPYRIGHT © 1991 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

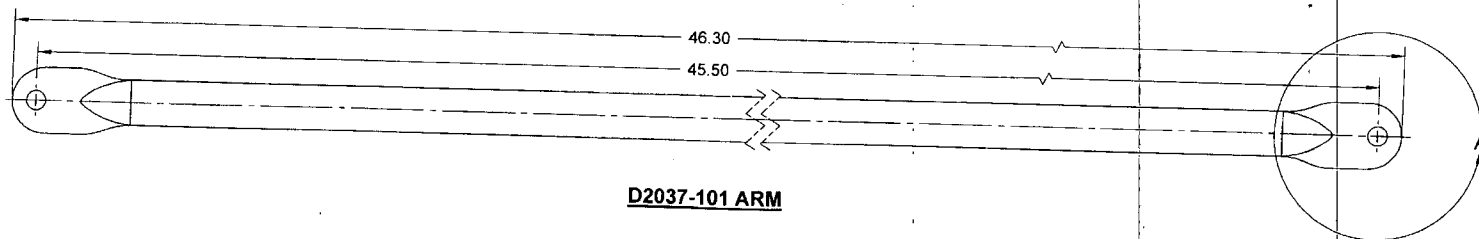
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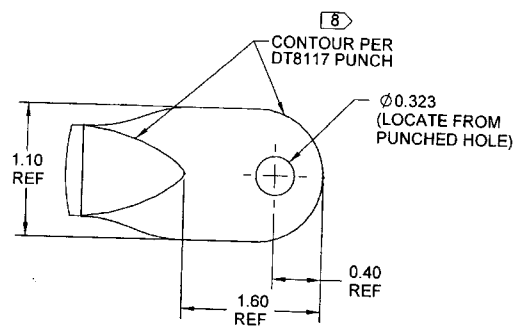
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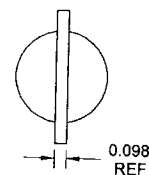
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D2037-101 ARM



DETAIL A
SCALE 2X
2 PL



DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2037	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ARM	NTS
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